



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3500-1
Job Sheet 184916



Part No: D3500-1

Job Qty: 30 ea

Part Name: Saddle



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/18/18

Job Tracking No:

Due Date: 11/12/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP Rev:A New Issue 06-06-15 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
90	Start up Operation	30 Ea	11/12/18	11/12/18	0.00	0.00	Start Up Machining-2	SBL
100	CNC Vertical Machining	30 pcs	11/12/18	11/12/18	0.15	37.50	HAAS1-3	SBL 18/11/30
120	QC	30 pcs	11/12/18	11/12/18	0.00	0.00	QC8	DR 18/12/03
130	HandFinish	30 pcs	11/12/18	11/12/18	0.00	0.97	HandFinish1	DR 18/12/03
140	Powdercoat	30 pcs	11/12/18	11/12/18	0.00	0.90	Powdercoat1	DR 18/12/03
150	QC	30 pcs	11/12/18	11/12/18	0.00	0.00	QC3	DAS 38
160	Packaging	30 pcs	11/12/18	11/12/18	0.00	0.00	Packaging3-1	ST406 6 JAN 2 2019
170	QC21-SA	30 Ea	11/12/18	11/12/18	0.00	0.00	QC21	9-80 21 JAN 2 2019

Part Op 100 - Program Batch No. 513/996 Double check by: DJR 1-Machine Step No 1 per Folio FA641 and inspect per
Descriptions: attached Dimension Sheets 2-Machine Step No 2 per Folio FA641 and inspect per attached Dimension Sheets 3-Machine
Step No 3 per Folio FA641 and inspect p
140 - START TIME: 2:00 0.1330 FINISH: 2:30 11/30/18

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6102-013	Saddle Billet	30 Ea (1 ea)	90-Start up Operation	5125529

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6102-013	30	6	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle	1.125Inches + 0.020 - 0.000	1.145 1.125	Radius	
2	Saddle	0.490Inches + 0.020 - 0.000	0.510 0.490	Radius	
3	Saddle	0.615Inches + 0.020 - 0.000	0.635 0.615		
4	Saddle	0.240Inches + 0.020 - 0.000	0.260 0.240		
5	Saddle	1.810Inches	1.830		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		

Environment ☐

Design ☐

Doc/Data ☐

Equip/Tooling ☐

Handling/Pre ☐

Material ☐

Internal Transport ☐

Tribal Knowledge ☐

LOA ☐

Substation ☐

Past Expiry Date ☐

Misidentified ☐

Container No: S131996

Part: D3500 - 1

Job No: 184916

Serial No/Batch: S131996

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/27/18

Power Loss/Surge ☐

Folio/Program ☐

Grain ☐

Weld ☐

Wrong Stock Pulled ☐

Out of Sequence ☐

Off-set ☐

Mislabeled ☐

Fit/Function ☐

Misaligned/off center ☐

Positioned Wrong ☐

Outside Dimensions ☐

Over/Under tolerance ☐

Part Incorrect ☐

Part Lost/Missing ☐

Part Moved ☐

Drawing ☐

Finish ☐

Misread ☐

Turning Sequence ☐

			+ 0.020	1.810	
			- 0.000		
6	Saddle	0.240Inches	+ 0.020 - 0.000	0.260 0.240	
7	Saddle	0.140Inches	+ 0.020 - 0.000	0.160 0.140	
8	Saddle	0.140Inches	+ 0.020 - 0.000	0.160 0.140	
9	Saddle	0.140Inches	+ 0.020 - 0.000	0.160 0.140	
10	Saddle	0.483Inches	+ 0.007 - 0.000	0.490 0.483	
11	Saddle	1.175Inches	+ 0.010 - 0.000	1.185 1.175	
12	Saddle	3.145Inches	+ 0.010 - 0.000	3.155 3.145	
13	Saddle	1.175Inches	+ 0.010 - 0.000	1.185 1.175	
14	Saddle	0.365Inches	+ 0.020 - 0.000	0.385 0.365	
15	Saddle	0.490Inches	+ 0.020 - 0.000	0.510 0.490	
16	Saddle	0.515Inches	+ 0.020 - 0.000	0.535 0.515	Radius
17	Saddle	1.575Inches	+ 0.020 - 0.000	1.595 1.575	Radius
18	Saddle	0.240Inches	+ 0.020 - 0.000	0.260 0.240	
19	Saddle	0.490Inches	+ 0.020 - 0.000	0.510 0.490	
20	Saddle	3.590Inches	+ 0.060 - 0.000	3.650 3.590	
21	Saddle	0.315Inches	+ 0.007 - 0.000	0.322 0.315	
22	Saddle	0.256Inches	+ 0.006 - 0.000	0.262 0.256	
23	Saddle	6.500Inches	+ 0.020 - 0.000	6.520 6.500	
24	Saddle	5.990Inches	+ 0.020 - 0.000	6.010 5.990	
25	Saddle	2.820Inches	+ 0.010 - 0.000	2.830 2.820	
26	Saddle	2.495Inches	+ 0.010 - 0.000	2.505 2.495	
27	Saddle	2.245Inches	+ 0.010 - 0.000	2.255 2.245	
28	Saddle	1.120Inches	+ 0.010 - 0.000	1.130 1.120	
29	Saddle	0.540Inches	+ 0.020 - 0.000	0.560 0.540	
30	Saddle	0.793Inches	+ 0.010 - 0.000	0.803 0.793	
31	Saddle	0.240Inches	+ 0.020 - 0.000	0.260 0.240	Radius
32	Saddle	0.040Inches	+ 0.020 - 0.000	0.060 0.040	
33	Saddle	0.100Inches	+ 0.020 - 0.000	0.120 0.100	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

DART AEROSPACE LTD				Work Order: 184 910	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.483	0.490 ✓		0.483	0.483	0.483	0.483	0.438
B	1.175	1.185 ✓		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155 ✓		3.500	3.500	3.500	3.500	3.500
D	1.175	1.185 ✓		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385 ✓		0.375	0.375	0.375	0.375	0.375
F	0.490	0.510 ✓		0.499	0.499	0.499	0.499	0.499
H	R0.515	R0.535 ✓		0.535	0.535	0.535	0.535	0.535
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		R1.578	1.588	1.583	1.583	1.583
J	0.240	0.260		0.255	0.255	0.250	0.249	0.451
K	0.490	0.510 ✓		0.500	0.500	0.500	0.500	0.500
L	3.590	3.650 ✓		3.620	3.620	3.620	3.620	3.620
M	0.315	0.322 ✓		0.316	0.316	0.316	0.316	0.316
N	0.256	0.262 ✓		0.257	0.257	0.257	0.257	0.257
O	6.500	6.520		6.510	6.509	6.511	6.508	6.510
P	5.990	6.010		6.000	6.000	6.003	6.000	6.000
Q	2.820	2.830 ✓		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505 ✓		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255 ✓		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130 ✓		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		0.547	0.553	0.550	0.550	0.550
V	0.793	0.803 ✓		0.799	0.798	0.798	0.798	0.798
W	R.240	R.260 ✓		0.250	0.250	0.250	0.250	0.250
X	0.040	0.060		0.048	0.048	0.048	0.048	0.048
Y	0.100	0.120		0.105	0.105	0.105	0.105	0.105
AA	R1.125	R1.145		1.127	R1.127	1.132	1.132	1.132
AB	R.490	R.510 ✓		R.500	R.500	R.500	R.500	R.500
AC	0.615	0.635 ✓		0.625	0.625	0.625	0.625	0.625
AD	0.240	0.260		0.260	0.260	0.256	0.256	0.256
AE	1.810	1.830 ✓		1.820	1.820	1.820	1.820	1.820
AF	0.240	0.260		0.251	0.252	0.252	0.251	0.252
AG	0.140	0.160		0.151	0.150	0.151	0.153	0.152
AH	0.140	0.160		0.155	0.158	0.154	0.153	0.153
AI	0.140	0.160		0.155	0.155	0.150	0.150	0.150
Accept/Reject								

Measured by:		Date:	
Audited by: mml		Date: 6/12/01	
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

DART AEROSPACE LTD				Work Order: 184 910	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				16	27	38	49	510
A	0.483	0.490	/	0.484	0.484	0.484	0.484	0.484
B	1.175	1.185	/	1.18	1.18	1.18	1.18	1.18
C	3.145	3.155	/	3.15	3.15	3.15	3.15	3.15
D	1.175	1.185	/	1.18	1.18	1.18	1.18	1.18
E	0.365	0.385	/	0.375	0.377	0.376	0.375	0.375
F	0.490	0.510	/	0.50	0.500	0.50	0.500	0.500
H	R0.515	R0.535	/	R.535	0.535	0.535	0.535	0.535
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595	/	1.583	1.583	1.583	1.583	1.583
J	0.240	0.260	/	0.250	0.250	0.250	0.250	0.251
K	0.490	0.510	/	0.5	0.500	0.50	0.500	0.500
L	3.590	3.650	/	3.620	3.620	3.620	3.620	3.620
M	0.315	0.322	/	0.316	0.316	0.316	0.316	0.316
N	0.256	0.262	/	0.257	0.257	0.257	0.257	0.257
O	6.500	6.520	/	6.510	6.510	6.510	6.510	6.508
P	5.990	6.010	/	6.000	6.000	6.000	6.000	6.000
Q	2.820	2.830	/	2.825	2.825	2.825	2.825	2.825
R	2.495	2.505	/	2.5	2.5	2.500	2.500	2.500
S	2.245	2.255	/	2.25	2.25	2.250	2.250	2.250
T	1.120	1.130	/	1.125	1.125	1.125	1.125	1.125
U	0.540	0.560	/	0.550	0.550	0.550	0.550	0.548
V	0.793	0.803	/	0.798	0.798	0.798	0.798	0.798
W	R.240	R.260	/	0.25	0.25	0.250	0.250	0.250
X	0.040	0.060	/	0.048	0.048	0.048	0.048	0.048
Y	0.100	0.120	/	0.102	0.102	0.102	0.102	0.102
AA	R1.125	R1.145	/	1.132	1.132	1.132	1.132	1.132
AB	R.490	R.510	/	0.500	0.500	0.500	0.500	0.500
AC	0.615	0.635	/	0.625	0.625	0.625	0.625	0.625
AD	0.240	0.260	/	0.255	0.256	0.256	0.256	0.256
AE	1.810	1.830	/	1.82	1.82	1.820	1.820	1.820
AF	0.240	0.260	/	0.257	0.257	0.257	0.257	0.257
AG	0.140	0.160	/	0.152	0.152	0.152	0.152	0.152
AH	0.140	0.160	/	0.153	0.154	0.153	0.150	0.150
AI	0.140	0.160	/	0.150	0.150	0.150	0.150	0.151
Accept/Reject								

Measured by:		Date:	
Audited by: <i>MM</i>		Date: 12/12/01	
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

DART AEROSPACE LTD				Work Order: 184 916	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				11	12	13	14	15
A	0.483	0.490		.484	.484	.484	.484	.484
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		.375	.375	.375	.375	.375
F	0.490	0.510		.498	.498	.498	.499	.500
H	R0.515	R0.535		.525	.525	.525	.525	.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.573	1.573	1.573	1.573	1.573
J	0.240	0.260		.252	.251	.250	.250	.250
K	0.490	0.510		.498	.498	.498	.499	.500
L	3.590	3.650		3.620	3.620	3.620	3.620	3.620
M	0.315	0.322		.316	.316	.316	.316	.316
N	0.256	0.262		.257	.257	.257	.257	.257
O	6.500	6.520		6.509	6.509	6.509	6.509	6.509
P	5.990	6.010		6.000	6.000	6.002	6.000	6.000
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		.549	.550	.550	.550	.498
V	0.793	0.803		.798	.798	.798	.798	.798
W	R.240	R.260		.250	.250	.250	.250	.250
X	0.040	0.060		.050	.050	.050	.050	.050
Y	0.100	0.120		.105	.107	.108	.105	.106
AA	R1.125	R1.145		1.133	1.133	1.133	1.133	1.133
AB	R.490	R.510		.500	.500	.500	.500	.500
AC	0.615	0.635		.627	.627	.627	.630	.627
AD	0.240	0.260		.256	.256	.255	.256	.255
AE	1.810	1.830		1.820	1.820	1.820	1.820	1.820
AF	0.240	0.260		.252	.252	.252	.252	.251
AG	0.140	0.160		.151	.151	.152	.153	.153
AH	0.140	0.160		.151	.150	.152	.152	.150
AI	0.140	0.160		.150	.151	.151	.148	.150

DAS Accept/Reject

Measured by: 57 9-89	Date: 18/11/29
Audited by: <i>mm</i>	Date: 18/12/01
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

DART AEROSPACE LTD				Work Order: 184 916	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				116	217	318	419	520
A	0.483	0.490		484	484	484	484	484
B	1.175	1.185		1180	1180	1180	1180	1180
C	3.145	3.155		3150	3150	3150	3150	3150
D	1.175	1.185		1180	1180	1180	1180	1180
E	0.365	0.385		375	375	375	376	375
F	0.490	0.510		500	500	500	500	499
H	R0.515	R0.535		525	525	525	525	525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1573	1573	1573	1573	1573
J	0.240	0.260		249	249	249	249	250
K	0.490	0.510		499	500	500	499	500
L	3.590	3.650		3620	3620	3620	3620	3620
M	0.315	0.322		316	316	316	316	316
N	0.256	0.262		257	257	257	257	257
O	6.500	6.520		6509	6509	6508	6508	6508
P	5.990	6.010		6000	6000	6001	6000	6000
Q	2.820	2.830		2825	2825	2825	2825	2825
R	2.495	2.505		2500	2500	2500	2500	2500
S	2.245	2.255		2250	2250	2250	2250	2250
T	1.120	1.130		1125	1125	1125	1125	1125
U	0.540	0.560		549	550	549	550	550
V	0.793	0.803		798	798	798	798	798
W	R.240	R.260		250	250	250	250	250
X	0.040	0.060		050	050	050	050	050
Y	0.100	0.120		107	106	110	105	106
AA	R1.125	R1.145		1133	1133	1133	1133	1133
AB	R.490	R.510		500	500	500	500	500
AC	0.615	0.635		628	630	630	632	632
AD	0.240	0.260		256	256	256	256	255
AE	1.810	1.830		1820	1820	1820	1820	1820
AF	0.240	0.260		252	252	252	252	251
AG	0.140	0.160		152	152	152	152	152
AH	0.140	0.160		150	150	151	151	150
AI	0.140	0.160		149	149	150	150	149

Accept/Reject

Measured by: DAS 57	Date: 18/11/29
Audited by: 9-89 <i>mm</i>	Date: 18/12/01
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

DART AEROSPACE LTD				Work Order: 184 916	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	21	22	23	24	25
A	0.483	0.490		.484	.484	.484	.484	.484
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		.375	.375	.375	.375	.375
F	0.490	0.510		.499	.499	.499	.499	.500
H	R0.515	R0.535		.525	.525	.525	.525	.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.583	1.583	1.583	1.583	1.583
J	0.240	0.260		.250	.251	.250	.250	.248
K	0.490	0.510		.499	.499	.499	.499	.500
L	3.590	3.650		3.620	3.620	3.620	3.620	3.620
M	0.315	0.322		.316	.316	.316	.316	.316
N	0.256	0.262		.257	.257	.257	.257	.257
O	6.500	6.520		6.510	6.508	6.509	6.508	6.509
P	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		.548	.550	.548	.550	.549
V	0.793	0.803		.798	.798	.798	.798	.798
W	R.240	R.260		.250	.250	.250	.250	.250
X	0.040	0.060		.050	.050	.050	.050	.050
Y	0.100	0.120		.106	.108	.105	.106	.105
AA	R1.125	R1.145		1.135	1.135	1.133	1.133	1.133
AB	R.490	R.510		.500	.500	.500	.500	.500
AC	0.615	0.635		.630	.630	.630	.630	.630
AD	0.240	0.260		.255	.258	.256	.256	.256
AE	1.810	1.830		1.820	1.820	1.820	1.821	1.821
AF	0.240	0.260		.252	.252	.252	.252	.253
AG	0.140	0.160		.152	.152	.151	.153	.153
AH	0.140	0.160		.150	.151	.150	.150	.151
AI	0.140	0.160		.150	.151	.150	.150	.150

DAS Accept/Reject

Measured by: 57 9-89	Date: 18/11/30
Audited by: <i>mmL</i>	Date: 18/12/01
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

DART AEROSPACE LTD				Work Order: 184 916	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				126	227	328	429	530
A	0.483	0.490		484	484	484	484	484
B	1.175	1.185		1180	1180	1180	1180	1180
C	3.145	3.155		3150	3150	3150	3150	3150
D	1.175	1.185		1180	1180	1180	1180	1180
E	0.365	0.385		375	375	375	375	375
F	0.490	0.510		500	499	499	500	500
H	R0.515	R0.535		525	525	525	525	525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1583	1583	1583	1583	1583
J	0.240	0.260		250	250	249	249	249
K	0.490	0.510		500	500	499	500	500
L	3.590	3.650		3620	3620	3620	3620	3620
M	0.315	0.322		316	316	316	316	316
N	0.256	0.262		257	257	257	257	257
O	6.500	6.520		6508	6508	6508	6508	6509
P	5.990	6.010		6000	6000	6000	6000	6000
Q	2.820	2.830		2825	2825	2825	2825	2825
R	2.495	2.505		2500	2500	2500	2500	2500
S	2.245	2.255		2250	2250	2250	2250	2250
T	1.120	1.130		1125	1125	1125	1125	1125
U	0.540	0.560		550	550	550	548	550
V	0.793	0.803		798	798	798	798	798
W	R.240	R.260		250	250	250	250	250
X	0.040	0.060		050	050	050	050	050
Y	0.100	0.120		105	106	008	105	106
AA	R1.125	R1.145		1133	1133	1133	1133	1133
AB	R.490	R.510		500	500	500	500	500
AC	0.615	0.635		630	630	630	630	630
AD	0.240	0.260		256	256	255	253	256
AE	1.810	1.830		1820	1820	1820	1820	1820
AF	0.240	0.260		252	252	252	251	251
AG	0.140	0.160		153	152	152	152	151
AH	0.140	0.160		151	150	150	150	151
AI	0.140	0.160		150	150	149	150	149

DAS Accept/Reject

Measured by: 57	Date: 18/11/30
Audited by: 9-89 mmc	Date: 18/12/01
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	